

1/26/2018

[Dart Hawkesbury] Job Sheet - Leroux, Jason



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5489-041

Job Sheet 171085



Part No: D5489-041

Job Qty: 4 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/26/18

Job Tracking No:

Created By: Jason Leroux

Due Date: 1/29/18

Type: SOLD

Description:

Note: URF17-729 IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE 1/10/29 AUTH SAO

RELEASED PD DATE 18.01.31

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/27/18	0.00	0.00	Start Up Waterjet		dc 18/01/29
100	Waterjet	4 pcs		1/27/18	0.00	2.59	Waterjet1		dc 18/01/29
110	QC	4 pcs		1/27/18	0.00	0.00	QC2 Waterjet-4		dc 18/01/29
120	QC	4 pcs		1/27/18	0.00	0.00	QC8-6		EB
130	Brake NC	4 pcs		1/27/18	0.00	2.52	Brake NC 1		SB
140	QC	4 pcs		1/27/18	0.00	0.00	QC5		EL
150	Autoweld 1	4 pcs		1/27/18	0.00	1.22	Automated welding		B x2
160	QC	4 pcs		1/27/18	0.00	0.00	QC10		SA
170	QC	4 pcs		1/27/18	0.00	0.00	QC5		18-1-30
180	HandFinish	4 pcs		1/29/18	0.00	1.33	HandFinish4		18-01-30
190	QC	4 pcs		1/29/18	0.00	0.00	QC3		PD 18.01.31
200	Packaging	4 pcs		1/29/18	0.00	0.00	Packaging3-2		
210	QC21-SA	4 Ea		1/29/18	0.00	0.00	QC21		FER 11 7 18

Part Op 100 - 1-Cut as per Dwg (D5489-1) Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 150 - ***SEE NOTE 8,10 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: 5024335

180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R

ROCKGUARD BATCH: 138714 exp: 12/18

200 - LOCATION : FP002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	8.7200 sf (2.18 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	9	127	0

Part Specifications

Specifications could not be found.

Plex 1/26/18 3:28 PM dart.leroux.jason



S036633



Wearplate Assembly

PART NO: D5489 – 041
Original Serial #: S036633

Revision:

Operation:

Change No:

Start up Operation 01/29/18

Job No: 171085

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____


 QA Closed: **DAS 53** Date: **APR 25 2018**

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

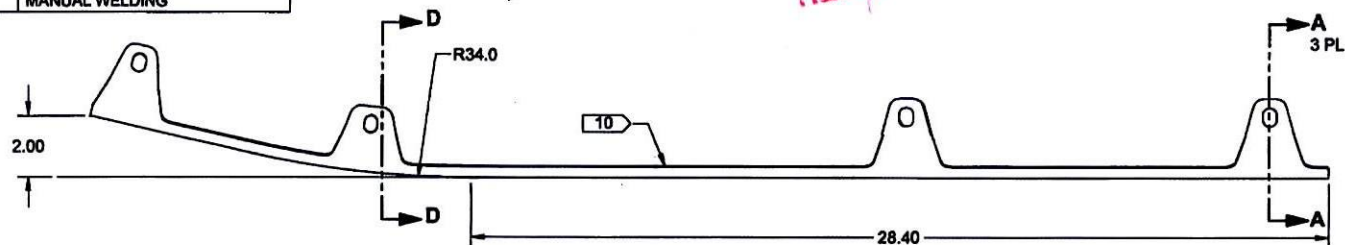
Work Order: 171083 Part No. D5489-041 NCR No. 18-0538	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☒</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☒	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐		
Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☒																														
Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐																														
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐																														
Large Fab	☐	Composite	☐	Supplier	☐																																

Date: 18/1/29	Step #: _____	QTY Effective: 2	MRB (QSI042) Approval DAS 12 9-89 18/1/29
----------------------	---------------	-------------------------	--

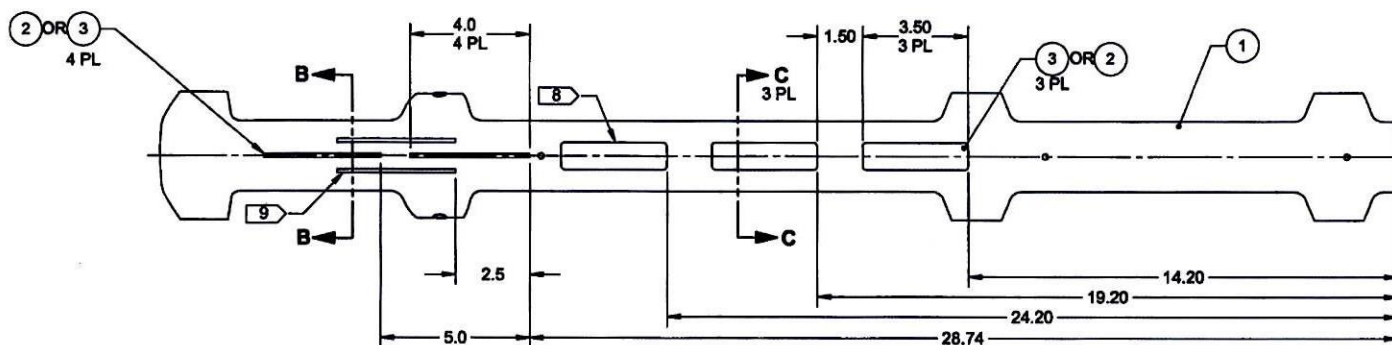
Description Work Order Deviation Tooling for wecrplates is not finalized. Weocrplates will be cut and bent to fit skidtube. Some flat bottom dimensions have shifted to align with skidtube holes. See attached dug mark-up for details.	Disposition All weocrplates require a test fit on a skidtube prior to shipment. Test fit was acceptable 18/1/31	Completed By DAS 12 9-89 18/1/31 Lead hand / Supervisor Approval Verification DAS 9 9-89 13-01-31 QC / QA Coordinator Approval DAS 9 9-89 13-01-31
--	--	---

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☒	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☒
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Pas Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER: _____			

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5489-041	WEARPLATE ASSEMBLY
1	1	D5489-1	WEARPLATE
2	A/R	8259	HARDCOAT SURFACING AUTOMATED WELDING
3	A/R	2059B	HARDCOAT SURFACING MANUAL WELDING



D5489-1 WEARPLATE
(MAKE FROM D5489-1F)



D5489-041 WEARPLATE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 2.5 lbs
- 8) WELDING: BUILD UP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.17 TO 0.20 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) WELDING: BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

UNDER REVIEW

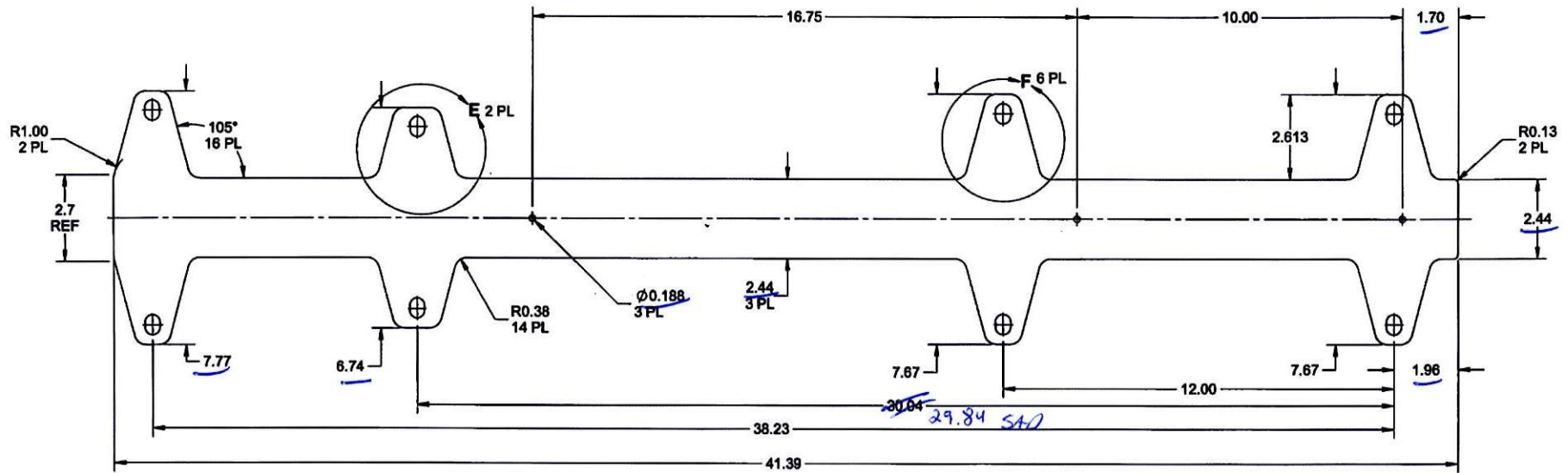
URF17-729 NO

RELEASED
2017-10-31
ECN 17-728

A	NEW ISSUE			SAD	17.08.10
REV.		DESCRIPTION		BY	DATE
DESIGN	SAD	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	NO				
CHECKED	AJS	DRAWING NO.	REV. A		
MFG. APPR.	DD	D5489	SHEET 1 OF 7		
APPROVED	WM	TITLE	SCALE		
DE APPR.	DS	WEARPLATE	NTS		
DATE	17.08.10	COPYRIGHT © 2017 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.					

APPROVED

REFERENCE ONLY



D5489-1F WEARPLATE
(FLAT PATTERN)

UNDER REVIEW

URF17-729 NO

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063"), PER MIL-S-5059 OR AMS 5513 (304), OR AMS 5524 (316), OR ASTM A240, OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.9 lbs

RELEASED
2017-10-31

APPROVED

DESIGN	SAD	DART AEROSPACE LTD	
DRAWN	NO	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5489	SHEET 2 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	17.08.10	COPYRIGHT © 2017 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Tuesday, January 30, 2018

Details			
Raised Date 11/8/2017	Status Open	Owner Monterroza, William	Number NCR17-6673
Target Date 2/28/2018	Standard		Severity MINOR
Process Inspection		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Engineering		Fault Category General\Design
Details			
due to manufacturing issue the following wear plate flat patterns were deviated from drawing.D5489-041, D5489-3, D5489-045 & D5489-047			
Keywords D412-742		Product D412-742	
Document		Root Cause Design	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 11/18/2017	Owner Downing, Eric M	Closed Date 11/8/2017	Closed By Downing, Eric M
Details			
parts were deviated due to manufacturing of first time parts. correct planning and tooling were not put in place prior to releasing design.			

Actions			
Number	Owner	Target Date	Completed Date
Details	Response		

Corrective Action			
Target Date 2/28/2018	Owner Monterroza, William	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Duval, David	2/28/2018	
adjust manufacturing process of create tooling.			

Implementing Corrective Action			
Target Date	Owner	Closed Date	Closed By
2/28/2018	Monterroza, William		
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
2	Monterroza, William	11/17/2017	11/9/2017
Implement action to prevent this from reoccurring,Assign Engineering personnel		Assign Steven and Nazim	

Verification & Review			
Target Date	Owner	Closed Date	Closed By
2/28/2018	Downing, Eric M		
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐					
Date : <u>18-01-30</u>		Step #: <u>120</u>		QTY Effective : <u>①</u>			MRB (QSI042) Approval <u>DAS</u> <u>12</u> <u>9-89</u> <u>10/1/30</u>		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification <u>DAS</u> <u>9</u> <u>9-89</u> <u>18-01-30</u> QC / QA Coordinator Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>18-01-30</u>	
<u>NCR 17-6673</u>				<u>fabricate as per drawing mock up</u>					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	☒ Drawing				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							